

52

SPLIT

DART AEROSPACE LTD		Work Order:	21953
Description: Support Assembly		Part Number:	D3278-041
Dwg: D3278 Rev. A		Qty:	100
		Page 1 of 2	

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveler DWG NOT REQUIRED 04.07.05	Er	04.11.23	100																				
2	MV	Cut blanks: 2.00" x 1.00" x 2.550" long Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick (M6061T6B1.000x02.000) Identify for D3278-1 Batch: M15549 M16241	Er	05/01/06	100																				
3	MV	Cut blanks: 2.00" x 1.00" x 2.550" long Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick (M6061T6B1.000x02.000) Identify for D3278-2 Batch: M16241	Er	05/01/06	100																				
4	MV	Machine D3278-1 as per Folio FA405 and Dwg D3278 Identify as D3278-1	Er	05/01/12	100																				
5	QC2	Inspect parts as they come off the CNC machine	Er	05/01/12	100																				
6	MV	Deburr and Tumble	Er	05/01/12	100																				
7	QC8	Second check	Er	05/01/13	100																				
8	MV	Machine D3278-2 as per Folio FA405 and Dwg D3278 Identify as D3278-2	Er	05/01/13	100																				
9	QC2	Inspect parts as they come off the CNC machine	Er	05/01/12	100																				
10	MV	Deburr and Tumble	Er	05/01/12	100																				
11	QC8	Second check	Er	05/01/13	100																				
12	FP	Acid etch and Alodine as per QSI 005 4.1	ML	05/01/13	100																				
13	QC5	Inspect work to Step 12	ML	05-01-19	100																				
14	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	ML	05-01-21	100																				
15	QC3	Inspect Powder Coat	ML	05-01-28	100																				
16	GA	Rivet spacers with support as per Dwg D3278. (Note: D3278-1/-2 are on BOM as material from Steps 2-3) Pick: Packing Kit <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3278-1</td><td>Support</td><td>B21953</td></tr><tr><td>1</td><td>D3278-2</td><td>Support</td><td>B21953</td></tr><tr><td>1</td><td>D3278-3</td><td>Spacer</td><td>B21961</td></tr><tr><td>4</td><td>MS20426AD3-6</td><td>Rivet</td><td>M1563</td></tr></table>	Qty	Part Number	Description	Batch	1	D3278-1	Support	B21953	1	D3278-2	Support	B21953	1	D3278-3	Spacer	B21961	4	MS20426AD3-6	Rivet	M1563	2	05-02-03	100
Qty	Part Number	Description	Batch																						
1	D3278-1	Support	B21953																						
1	D3278-2	Support	B21953																						
1	D3278-3	Spacer	B21961																						
4	MS20426AD3-6	Rivet	M1563																						
17	QC5	Inspect work to Step 16	AB	05-02-04	100																				

RELEASED

2/04/04-04-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-02-04	16	one D3278-041 scrap bad rivets	18 p-acton	destroy	18 05-02-04	18 05-02-04	18 p-acton	18 05-02-04

Part No: D3278-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Q Date: 05/02/14

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	21953
Description: Support Assembly		Part Number:	D3278-041
Dwg: D3278 Rev. A		Qty:	100
		Page 2 of 2	

Step	Location	Procedure	By	Date	Qty																				
18	GA	Assemble support as per Dwg D3278 Pick: Packing Kit <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>2</td><td>D2230-1</td><td>Clamp</td><td>M 21954</td></tr><tr><td>2</td><td>AN4-13A</td><td>Bolt</td><td>M 16114</td></tr><tr><td>4</td><td>AN960JD416</td><td>Washer</td><td>M 15020 M 1432 M 15993</td></tr><tr><td>2</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M 13272 M 15020</td></tr></tbody></table> Identify as D3278-041 M 14764	Qty	Part Number	Description	Batch	2	D2230-1	Clamp	M 21954	2	AN4-13A	Bolt	M 16114	4	AN960JD416	Washer	M 15020 M 1432 M 15993	2	MS21042L4	Nut (or -4)	M 13272 M 15020	SB	05/02/08	95
Qty	Part Number	Description	Batch																						
2	D2230-1	Clamp	M 21954																						
2	AN4-13A	Bolt	M 16114																						
4	AN960JD416	Washer	M 15020 M 1432 M 15993																						
2	MS21042L4	Nut (or -4)	M 13272 M 15020																						
19	QC5	Inspect work to Step 18		05.02.08	95																				
20	ST	Identify and Stock		05.02.11	95																				
21	AC	Cost / part <u>30.03</u>		05.02.16	95																				
22	DC	Close W/O <u>29.88</u> Inspect Level 21		05.02.16	95																				

Rev	Date	Change	Revised By	Approved
A	04.04.19	New issue	KJ/JLM	

RELEASED

04.04.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	21953
Description: Support		Part Number:	D3278-1
Inspection Dwg: D3278 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	0.098	✓			
0.365	+/-0.010	0.366	✓			
0.615	+/-0.010	0.621	✓			
0.250	+/-0.010	0.254	✓			
1.480	+/-0.010	1.480	✓			
R0.125	+/-0.010	0.125	✓			
0.125	+/-0.010	0.127	✓			
2.439	+/-0.010	2.436	✓			
1.980	+/-0.010	1.983	✓			
R0.130	+/-0.010	0.130	✓			
Ø0.257	+0.005/-0.000	0.257	✓			
R0.375	+/-0.010	0.375	✓			
0.875	+/-0.010	0.874	✓			
0.500	+/-0.010	0.499				
R0.400	+/-0.010	0.400				
1.720	+/-0.010	1.720	✓			
R0.125	+/-0.010	0.125	✓			
0.125	+/-0.010	0.130	✓			

Measured by: <i>EP</i>	Audited by: <i>gml</i>	Prototype Approval:	N/A
Date: 05/01/12	Date: 05/01/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue	KJ/JLM	<i>[Signature]</i>

RELEASED

[Signature] 04-06-12

DART AEROSPACE LTD		Work Order:	21953
Description: Support		Part Number:	D3278-2
Inspection Dwg: D3278	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

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Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	0.098	✓			
0.365	+/-0.010	0.370	✓			
0.615	+/-0.010	0.620	✓			
0.250	+/-0.010	0.250	✓			
1.480	+/-0.010	1.479	✓			
R0.125	+/-0.010	0.125	✓			
0.125	+/-0.010	0.127	✓			
2.439	+/-0.010	2.438	✓			
1.980	+/-0.010	1.986	✓			
R0.130	+/-0.010	0.130	✓			
Ø0.257	+0.005/-0.000	0.257	✓			
R0.375	+/-0.010	0.375	✓			
0.875	+/-0.010	0.874	✓			
0.500	+/-0.010	0.498	✓			
R0.400	+/-0.010	0.400	✓			
1.720	+/-0.010	1.720	✓			
R0.125	+/-0.010	0.125	✓			
0.125	+/-0.010	0.130	✓			

Measured by: <i>GP</i>	Audited by: <i>mf</i>	Prototype Approval:	N/A
Date: 05/01/11	Date: 05/01/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue	KJ/JLM	<i>[Signature]</i>

RELEASED

[Signature] 04.10.17

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 22, 2004
03:12 pm

Work Order No : 0021953
Project Name : D3278-041
Project For : WK452
Work Order Type : Main
Main WO Number :
House Part Number : D3278-041
Description : Support Assembly
Manufactured : Yes
Amount Req'd : 100
Amount Done : 0
Start Date : 11-22-04
Est Finish Date : 12-20-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Margin : 0.000%
Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00